

Work Order ID 53399

November 03, 2009 3:21:15 PM

Page 1

Item ID: D350-607-043A Accept

Revision ID:

Item Name: Heli-Utility-Basket (Automatic Lid Operen) *mf*

Start Date: 11/4/2009 Start Qty: 1.00

Required Date: 11/11/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: *mf* Date: *09-11-03* Tooling:

QC: Date: SPC (Y/N):

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

DSI 9473

A

100 DOCUMENT CONTROL 0.00



DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-607-043A CHG001

110 Pick Kit 0.00



Packaging

Memo

0.00

Packaging

120 Small Fab 0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D350-607
Seal Support Gusset with Sikaflex -291

Batch: *1112391*

Exp Date: *10/20*

BR 09-11-11

HJ for BG 09/11/11

9/11/11 QSP



*See PTO
py 10
w/ pick
list.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53399

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Item ID: D350-607-043A

Accept

Revision ID:

Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)

Start Date: 11/4/2009 Start Qty: 1.00

Required Date: 11/11/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

140

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

See
PTO
pg 10
of Pick
list

glub sl

ms 11-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item ID: D350-607-043A

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Revision ID:

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Start Date: 11/4/2009 Start Qty: 1.00

Required Date: 11/11/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____

QC: _____ Date: _____ SPC (Y/N): _____

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-607-043A
Location: DNB

170

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

POSITIVE RECALLEFFECTIVE 9/11/12AUTH hRELEASED MDDATE 09/11/12POSITIVE
RECALL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 53399



Parent Item: D350-607-043A



Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)




Start Date: 11/4/2009

Required Date: 11/11/2009

Comments: IPP Rev A 09.11.03 new issue EC verified by:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN310-4  NUT		Purchased	No			120	Each	84.0000	2.0000		9/11/9	SL
				<u>Warehouse</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
				<u>Location</u>								
				Main Warehouse								
				ST			84					
				110098			34					
				112969			50					
AN3-16A  Bolt		Purchased	No			120	Each	89.0000	2.0000		9/11/9	SL
				<u>Warehouse</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
				<u>Location</u>								
				Main Warehouse								
				ST			89					
				111965			89					
AN3C11A  BOLT		Purchased	No			120	Each	100.0000	2.0000		9/11/9	SL
				<u>Warehouse</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
				<u>Location</u>								
				Main Warehouse								
				ST			100					
				112255			50					
				112969			50					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 53399

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)

Comments: IPP Rev A 09.11.03 new issue EC verified by:DD


Start Date: 11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN3C15A		Purchased	No			120	Each	100.0000	2.0000			
												
Bolt												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse
ST

100

112255


50

112969

50

9/11/9 SP

2X50

AN4-13A		Purchased	No			120	Each	289.0000	2.0000			
												
Bolt												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse
ST

289

107321

1

107534

5

107959

23

109285

37

110552

66

110865

3

111477

9

111925

7

112314

138

17406

0

51764

0

9/11/9 SP

2X50

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W/O:		WORK ORDER CHANGES					
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Work Order ID: 53399



Parent Item: D350-607-043A



Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)

Start Date: 11/4/2009

Required Date: 11/11/2009

Comments: IPP Rev A 09.11.03 new issue EC verified by:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-22A		Purchased	No			120	Each	282.0000	5.0000			
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Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	282	
104937	8	
107715	5	
108483	69	
111965	200	

9/11/09 SP

AN5-17A		Purchased	No			120	Each	92.0000	4.0000			
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Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	92	
102140	4	
107939	2	
110625	2	
111965	4	
112314	30	
112385	50	

9/11/09 SP

4-50

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 53399



Parent Item: D350-607-043A



Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)

Start Date: 11/4/2009

Required Date: 11/11/2009

Comments: IPP Rev A 09.11.03 new issue EC verified by:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416		Purchased	No			120	Each	4,501.000	14,0000			



Washer



9/11/9 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	4501	
108161	519	
110523	340	
111279	101	
111916	482	
112314	3059	
16941	0	

14x54

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53399



Parent Item: D350-607-043A



Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)

Start Date: 11/4/2009

Required Date: 11/11/2009

Comments: IPP Rev A 09.11.03 new issue EC verified by:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516		Purchased	No			120	Each	1,528.000	4.0000			



Washer



9/11/09 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1528	
100564	2	
106167	6	
107534	34	
107959	43	
108246	46	
108672	2	
109059	49	
109752	22	
110363	46	
110523	57	
111279	39	
112082	68	
112314	500	
112794	114	
112828	500	

4x 500

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53399



Parent Item: D350-607-043A



Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)

Start Date: 11/4/2009

Required Date: 11/11/2009

Comments: IPP Rev A 09.11.03 new issue EC verified by:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD8 Washer		Purchased	No			120	Each	1,427.000	2.0000			

9/11/9 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1427	
107091	9	
108335	11	
110382	48	
110917	3	
111578	62	
112314	500	
112385	794	

D2022-101RevN/A Spacer		Manufactured	No			120	Each	560.0000	5.0000			
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2x50

9/11/9 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST504	560	
45885	360	
50746	100	
52325	100	

5x50

D2221RevH 350 Basket Base		Manufactured	No			120	Each	0.0000	1.0000			
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53402

BR 09-11-10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 53399

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)

Start Date: 11/4/2009

Required Date: 11/11/2009

Comments: IPP Rev A 09.11.03 new issue EC verified by:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2258-200RevC

Manufactured

No

120

Each

9.0000

1.0000



Placard 2001b

9/11/9 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

9

48350

9

1x50

D2530RevB

Manufactured

No

120

Each

10.0000

1.0000



Handle Weldment

9/11/9 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

51124

1

Main Warehouse

ST506

9

52280

9

1x50

D2535RevA

Manufactured

No

120

Each

48.0000

2.0000



Spring

9/11/9 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

48

46580

48

2x50

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 53399

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)






Comments: IPP Rev A 09.11.03 new issue EC verified by:DD

Start Date: 11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2537RevA1  Bushing		Manufactured	No			120	Each	109.0000	2.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>52994</div> <div>53181</div> <div>Loc Qty</div> <div>109</div> <div>49</div> <div>60</div> <div>Loc Code</div>												
D2728-3RevB  Dart Logo label		Manufactured	No			120	Each	0.0000	2.0000			
D2931RevA  Bumper		Manufactured	No			120	Each	955.0000	2.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>46064</div> <div>Loc Qty</div> <div>955</div> <div>955</div> <div>Loc Code</div>												
D2989-041RevD  Basket Lid Assembly		Manufactured	No			120	Each	0.0000	1.0000			
D2989-043RevD  Basket Lid Assembly		Manufactured	No			120	Each	0.0000	1.0000			

9/11/950

2x50

B22553 of 9/11/9

9/11/951

2x50

BR 09-11-10

BR 09-11-10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 53399

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)




Comments: IPP Rev A 09.11.03 new issue EC verified by:DD

Start Date: 11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3953-11  Gas Spring Spacer		Manufactured	No			120	Each	40.0000	1.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST139C</div> <div>52767</div> <div>40</div> <div>40</div>												
<div>Loc Qty</div> <div>Loc Code</div> <div>1x SP</div> <div>9/11/9 SP</div>												
D3953-15  Gas Spring Bracket		Manufactured	No			120	Each	14.0000	1.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>52762</div> <div>14</div> <div>14</div>												
<div>Loc Qty</div> <div>Loc Code</div> <div>1x SP</div> <div>9/11/9 SP</div>												
D3953-17  Gas Spring Spacer		Manufactured	No			120	Each	24.0000	1.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>52763</div> <div>24</div> <div>24</div>												
<div>Loc Qty</div> <div>Loc Code</div> <div>1x SP</div> <div>9/11/9 SP</div>												

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Work Order ID: 53399

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)





Comments: IPP Rev A 09.11.03 new issue EC verified by:DD

Start Date: 11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3953-3  Gas Spring Stud, Lid		Manufactured	No			120	Each	20.0000	1.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST139B</div> <div>52757</div> <div>Loc Qty</div> <div>20</div> <div>20</div> <div>Loc Code</div>												
D3953-5  Gas Spring Stud, Base		Manufactured	No			120	Each	20.0000	2.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST139C</div> <div>52809</div> <div>Loc Qty</div> <div>20</div> <div>20</div> <div>Loc Code</div>												
D3953-9  Gas Spring Washer		Manufactured	No			120	Each	40.0000	2.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST139C</div> <div>52759</div> <div>Loc Qty</div> <div>40</div> <div>40</div> <div>Loc Code</div>												
D3969-1  Gas Spring (Basket Lid)		Manufactured	No			120	Each	0.0000	1.0000			

9/11/9 sl

53431 2X 9/11/9 sl

9/11/9 sl

2x sl

52889 9/11/10 sl



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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
05.11.11	120						

Part No: D350-607-043 PAR #: _____ Fault Category: Eng dwg NCR: (Yes) No DQA: / Date: 05.12.13
 Resolution: Documentation revised Disposition: other QA: N/C Closed: / Date: 05.12.13

NCR: <u>53399</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05.11.11	120	The Rev. A D353-9 washer was found to be too thick and upon assembly it would not allow the cutter pin to pass through the bolt.	<u>[Signature]</u>	Dwg Prelim Rev. B is being used the have the washer made to 0.050" min ± 0.010 . See Alan Stocker.	<u>[Signature]</u>	<u>05.12.11</u>	<u>[Signature]</u>	<u>05.11.11</u>
		R.C. Eng drawing.	<u>[Signature]</u>	Machine new - 9 washers per Rev. B prelim. using Delrin II M109183	<u>[Signature]</u>	<u>09/11/13</u>	<u>[Signature]</u>	<u>[Signature]</u>
			<u>[Signature]</u>	ASSEMBLE per dwg. Rev. B released	<u>[Signature]</u>	<u>09.11.11</u>	<u>[Signature]</u>	<u>05.11.11</u>

NOTE: Date & initial all entries

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Page 12

Work Order ID: 53399

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)



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Page 11

Work Order ID: 53399

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)

Start Date: 11/4/2009

Required Date: 11/11/2009

Comments: IPP Rev A 09.11.03 new issue EC verified by:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
k607-043RevCHG005 Pk Kit - D350-607-043 MS20600-AD4W3 Cherry Rivets		Manufactured	No			120	Each	0.0000	1.0000			
		Purchased	No			120	Each	2,533.000	2.0000			

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	2533	
102929	37	
104715	10	
106375	518	
107939	1000	
111636	968	

MS21042L3 Nut	Purchased	No				120	Each	3,280.000	2.0000			
------------------	-----------	----	--	--	--	-----	------	-----------	--------	--	--	--

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	3280	
110844	32	
111274	29	
111668	719	
112314	2000	
112385	500	

53418 P 9/11/12

9/11/9 SP

2x SP

9/11/9 SP

2x SP

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Page 11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	10	U607-04A chg 005 is route 110, not 120					

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 03, 2009 3:21:14 PM

Page 13

Work Order ID: 53399

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)

Comments: IPP Rev A 09.11.03 new issue EC verified by:DD

Start Date: 11/4/2009

Required Date: 11/11/2009


Start Qty: 1.00

Required Qty: 1.00



Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21043-3		Purchased	No			120	Each	5,023.000	4.0000			
												
Nut												

Warehouse	Loc Qty	Loc Code
Location		
OFFSHORE		
FG	80	
103691	80	
Main Warehouse		
ST	4943	
111819	78	
112243	39	
112314	4826	

MS24665-2-12		Purchased	No			120	Each	192.0000	2.0000			
												
COTTER PIN												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	192	
111499	192	

NAS1149C0332	AN960C10L	Purchased	No			120	Each	0.0000	4.0000			
												
Washer												
NAS1149C0432H	AN960C416L	Purchased	No			120	Each	0.0000	2.0000			
												
Washer												

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Page 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53399



Parent Item: D350-607-043A



Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)


Start Date: 11/4/2009

Required Date: 11/11/2009

Comments: IPP Rev A 09.11.03 new issue EC verified by:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H4  Washer		Purchased	No			120	Each	194.0000	2.0000		9/11/9	SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

194

111294

94

111525

100

2x SP

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Page 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND DRAWING D350-607 REV. F OR SUBSEQUENT APPROVED REVISION

REF CANADIAN STC: SH94-14

FAA STC: SR00213NY

EASA STC: EASA.IM.R.S.01405

THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI), IS TO PROVIDE OPERATORS OF AS350 / 355 ROTORCRAFT EQUIPPED WITH DART D350-607-041 HELI UTILITY BASKETS WITH AN UPGRADE KIT TO REPLACE THE EXISTING LID PROP ARM WITH 2 GAS SPRINGS.

FOR OPERATORS EQUIPPED WITH D350-607-043/045/047 HELI UTILITY BASKETS THIS DSI WILL PROVIDE AN UPGRADE KIT TO REPLACE THE EXISTING LID PROP ARM WITH 1 GAS SPRING.

ITEM No.	QTY -141	QTY -143	QTY -145	PART NUMBER	DESCRIPTION
1	X			D350-607-141	GAS SPRING KIT INSTALLATION (FOR USE ON -041 BASKET*)
2		X		D350-607-143	GAS SPRING KIT INSTALLATION (FOR USE ON -043/-047 BASKET*)
3			X	D350-607-145	GAS SPRING KIT INSTALLATION (FOR USE ON -045 BASKET*)
4	2		1	D3953-1	GAS SPRING BRACKET
5	2	1	1	D3953-3	GAS SPRING STUD (LID)
6	2	1	1	D3953-5	GAS SPRING STUD (BASE)
7	2	1	1	D3953-7	GAS SPRING SPACER
8	4	2	2	D3953-9	GAS SPRING WASHER
9	2	1	1	D3953-11	GAS SPRING SPACER
10	2		1	D3953-13	GAS SPRING SPACER
11		1		D3953-15	GAS SPRING BRACKET
12		1		D3953-17	GAS SPRING SPACER
13	2	1	1	D3969-1	GAS SPRING
14	4	2	2	AN3C11A	BOLT
15		2		AN3C15A	BOLT
18	4		2	AN3C16A	BOLT
19	4	2	2	AN310-4	CASTELLATED NUT
20	8	4	4	MS21043-3	NUT
21	4	2	2	MS24665-212	COTTER PIN
22	8	4	4	NAS1149C0332	WASHER
23	4	2	2	NAS1149C0432H	WASHER

***NOTE:** FOR CUSTOMERS WISHING TO ORDER NEW BASKETS WITH THE GAS SPRING KIT PRE-INSTALLED USE THE FOLLOWING NUMBERS:

D350-607-041 BASKET WITH GAS SPRING UPGRADE KIT = D350-607-041A

D350-607-043 BASKET WITH GAS SPRING UPGRADE KIT = D350-607-043A

D350-607-045 BASKET WITH GAS SPRING UPGRADE KIT = D350-607-045A




D350-607-047 BASKET WITH GAS SPRING UPGRADE KIT = D350-607-047A

* 53399

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 09.09.15
CERT. NO.: SH94-14
ISSUE NO.: 4

A	NEW ISSUE	AJS	09.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9473	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		GAS SPRING UPGRADE KIT	NTS
DATE	09.09.15	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FOR D350-607-041 BASKETS, REPLACE THE EXISTING D2332-041 PROP ARM ASSEMBLY AS FOLLOWS:

D350-607-141 GAS SPRING KIT INSTALLATION

NOTE: ONCE THIS MODIFICATION IS COMPLETE YOU WILL NOT BE ABLE TO RE-INSTALL THE D2332-041 PROP ARM.

- 1) REMOVE THE D2332-041 PROP ARM.
- 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON BOTH ENDS OF THE BASKET AS SHOWN IN FIGURE 1 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
- 3) LOCATE THE D3953-1 GAS SPRING BRACKET AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL A. INSTALL THE D3953-1 GAS SPRING BRACKET & D3953-13 GAS SPRING SPACER USING 2X AN3C16A BOLT, 2X NAS1149C0332 WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW E-E.
- 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL B. FASTEN D3953-5 IAW VIEW F-F USING 2X AN3C11A BOLT, 2X NAS1149C0332 WASHER & 2X MS21043-3 NUT.
- 5) INSTALL 1X D3953-11 GAS SPRING SPACER ONTO THE D3953-5 STUD AS SHOWN IN VIEW F-F. INSTALL THE LARGE END OF THE D3969-1 GAS SPRING SPRING ONTO THE D3953-5 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432H WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW F-F. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- 6) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-1 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING AS SHOWN IN VIEW E-E. RAISE THE BASKET LID AND INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432H WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW E-E. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.

NOTE: THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A $\frac{9}{16}$ OPEN END SPANNER / WRENCH.

NOTE: WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.

7) REPEAT STEPS 2 THROUGH 6 AT THE OTHER END OF THE BASKET.

8) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRINGS SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.




#53399

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.09.15
CERT. NO.: SH94-14
ISSUE NO.: 4

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9473	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		GAS SPRING UPGRADE KIT	NTS
DATE	09.09.15	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FOR D350-607-043/-047 BASKETS REPLACE THE EXISTING D2332-041 PROP ARM ASSEMBLY AS FOLLOWS:

D350-607-143 GAS SPRING KIT INSTALLATION

NOTE: THIS KIT MAY BE INSTALLED AT EITHER END OF THE BASKET. HOWEVER, THE PROP ARM MUST BE REMOVED IN EITHER CASE AS IT WILL INTERFERE WITH THE FUNCTION OF THE GAS SPRING.

- 1) REMOVE THE D2332-041 PROP ARM.
- 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON THE END OF THE BASKET WHERE THE GAS SPRING KIT IS BE INSTALLED AS SHOWN IN FIGURE 2 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
- 3) LOCATE THE D3953-15 GAS SPRING BRACKET AS SHOWN IN FIGURE 2. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL C. INSTALL THE D3953-15 GAS SPRING BRACKET & D3953-17 GAS SPRING SPACER USING 2X AN3C15A BOLT, 2X NAS1149C0332 WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW G-G.
- 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 2. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL D. INSTALL 2X AN3C11A BOLT, 2X NAS1149C0332 WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW H-H. INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432H WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW H-H. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- 5) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-15 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING STUD AS SHOWN IN VIEW G-G. RAISE THE BASKET LID AND INSTALL THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432H WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW G-G. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.

NOTE: THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A $\frac{9}{16}$ OPEN END SPANNER / WRENCH.

NOTE: WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.

- 6) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRING SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.




CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.09.15
CERT. NO.: SH94-14
ISSUE NO.: 4

53369

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9473	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		GAS SPRING UPGRADE KIT	NTS
DATE	09.09.15	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FOR D350-607-045 BASKETS REPLACE THE EXISTING D2332-041 PROP ARM ASSEMBLY AS FOLLOWS:

D350-607-145 GAS SPRING KIT INSTALLATION

NOTE: THIS KIT MAY BE INSTALLED AT EITHER END OF THE BASKET. HOWEVER, THE PROP ARM MUST BE REMOVED IN EITHER CASE AS IT WILL INTERFERE WITH THE FUNCTION OF THE GAS SPRING.

- 1) REMOVE THE D2332-041 PROP ARM.
 - 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON THE END OF THE BASKET WHERE THE GAS SPRING KIT IS BE INSTALLED AS SHOWN IN FIGURE 1 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
 - 3) LOCATE THE D3953-1 GAS SPRING BRACKET AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL A. INSTALL THE D3953-1 GAS SPRING BRACKET & D3953-13 GAS SPRING SPACER USING 2X AN3C16A BOLT, 2X NAS1149C0332 WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW E-E.
 - 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL B. FASTEN D3953-5 IAW VIEW F-F USING 2X AN3C11A BOLT, 2X NAS1149C0332 WASHER & 2X MS21043-3 NUT.
 - 5) INSTALL 1X D3953-11 GAS SPRING SPACER ONTO THE D3953-5 STUD AS SHOWN IN VIEW F-F. INSTALL THE LARGE END OF THE D3969-1 GAS SPRING SPRING ONTO THE D3953-5 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432H WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW F-F. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
 - 6) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-1 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING AS SHOWN IN VIEW E-E. RAISE THE BASKET LID AND INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432H WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW E-E. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- NOTE:** THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A $\frac{9}{16}$ OPEN END SPANNER / WRENCH.

NOTE: WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.

- 7) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRING SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.




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BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.09.15
CERT. NO.: SH94-14
ISSUE NO.: 4

#53399

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MFG. APPR.	N/A	DSI 9473	SHEET 4 OF 8
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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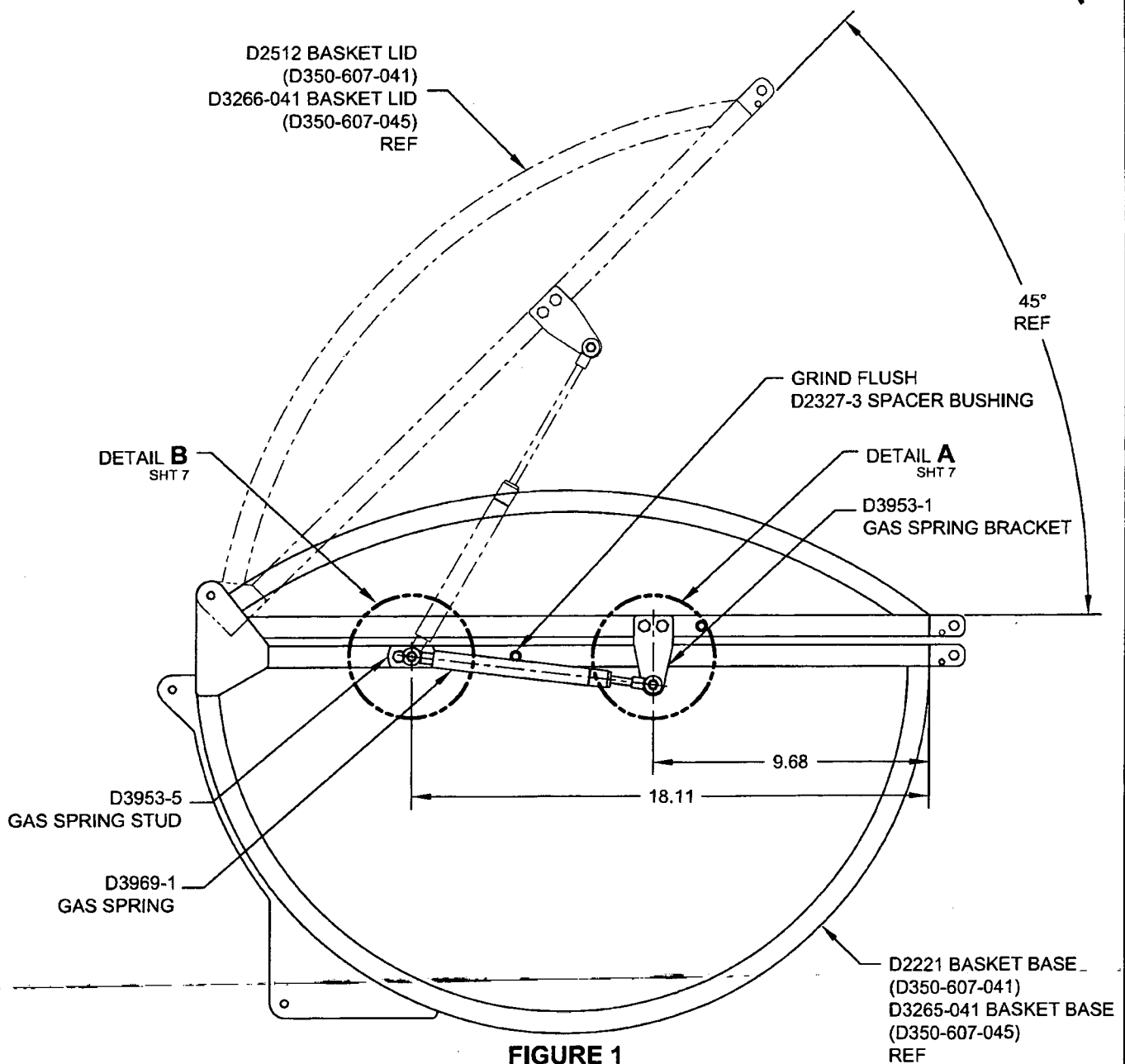


FIGURE 1

D350-607-141 GAS SPRING KIT INSTALLATION

(BOTH ENDS)

D350-607-145 GAS SPRING KIT INSTALLATION




(1 END ONLY)

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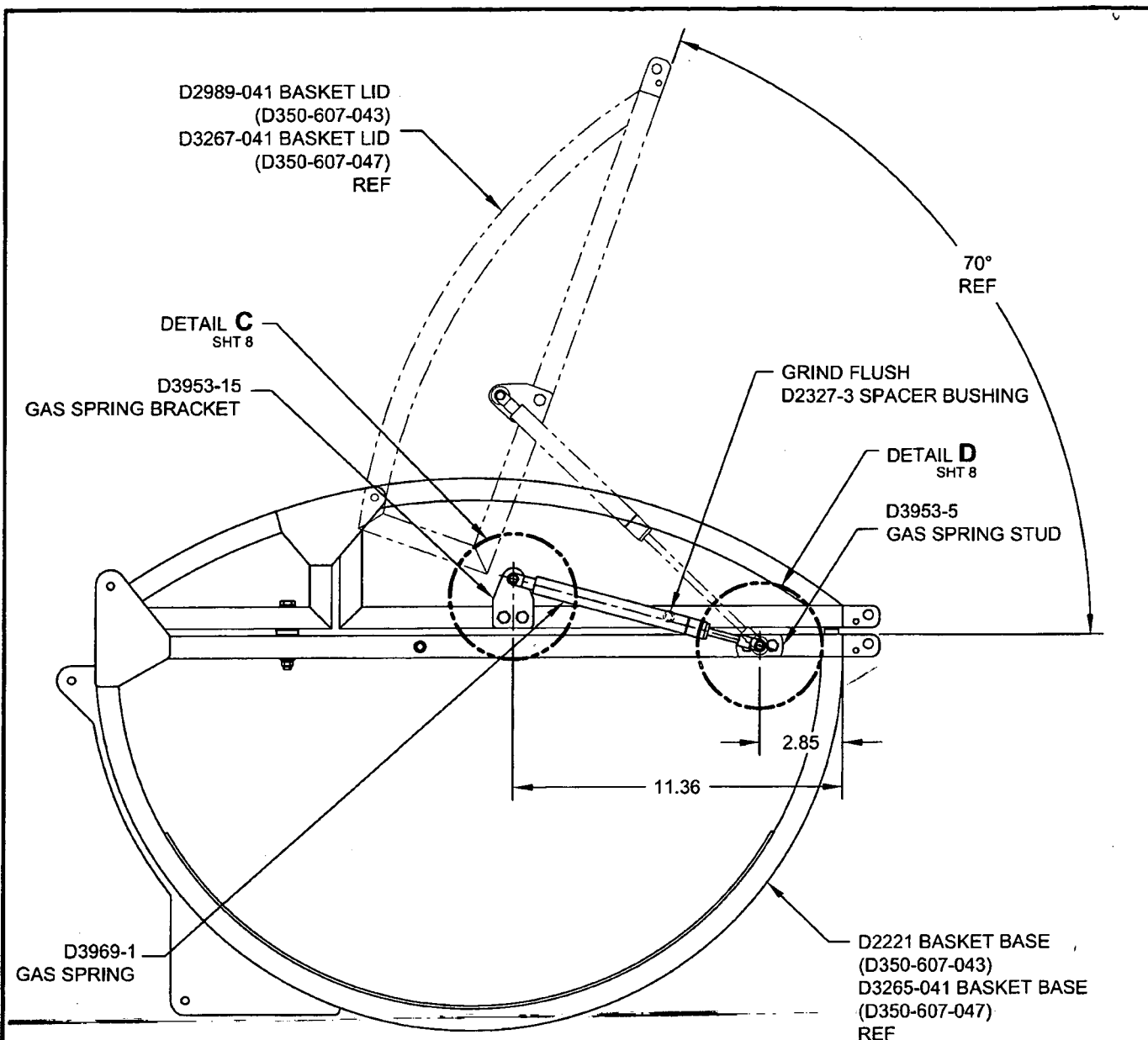


FIGURE 2
D350-607-143 GAS SPRING KIT INSTALLATION
 (1 END ONLY)

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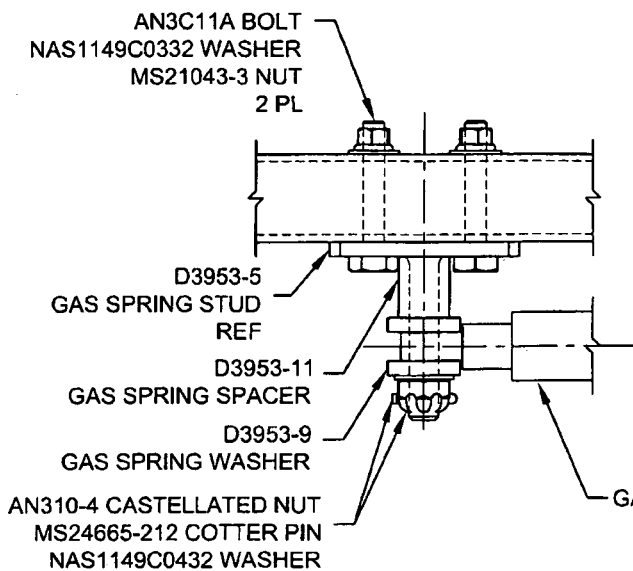
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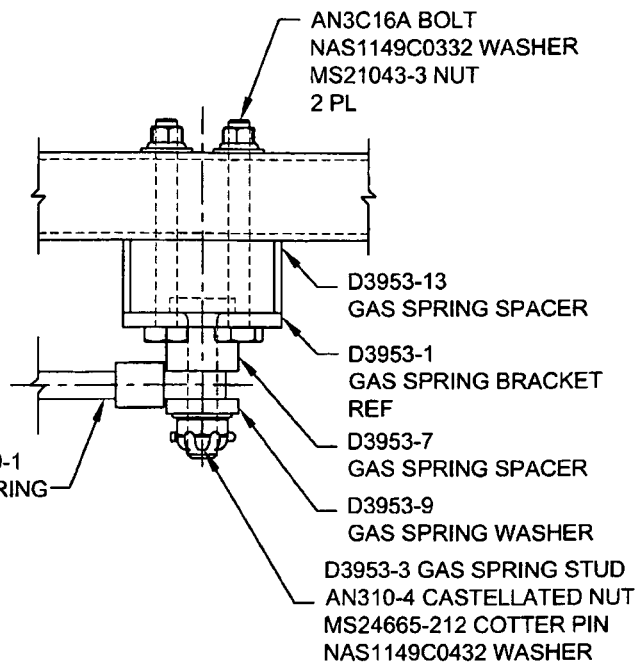
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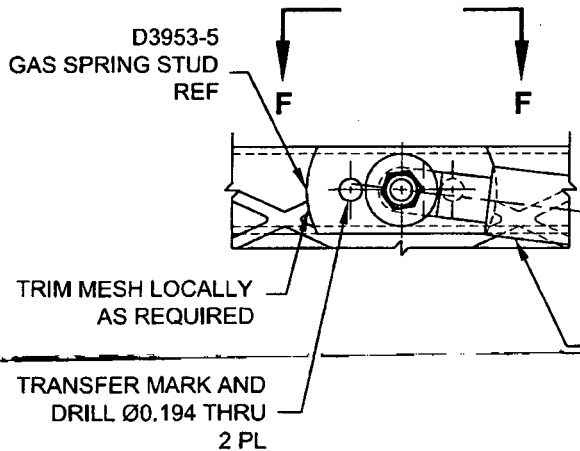
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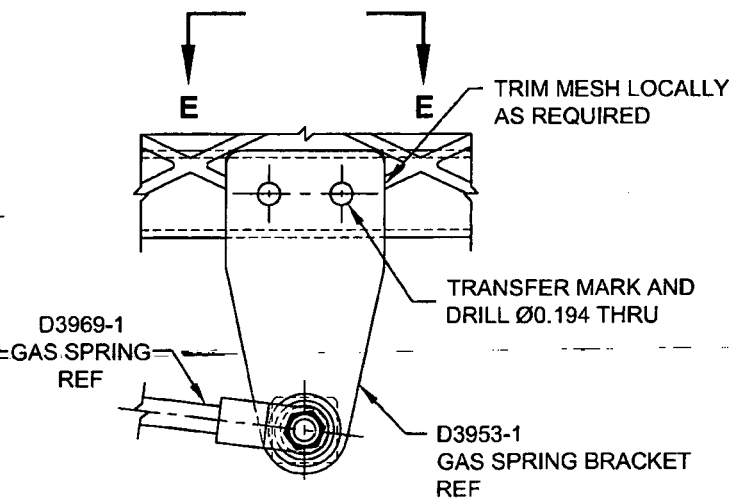
VIEW F-F



VIEW E-E



DETAIL B



DETAIL A




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AN3C15A BOLT
NAS1149C0332 WASHER
MS21043-3 NUT
2 PL

D3953-17
GAS SPRING SPACER

D3953-15
GAS SPRING BRACKET
REF

D3953-7
GAS SPRING SPACER

D3953-9
GAS SPRING WASHER

D3953-3 GAS SPRING STUD
AN310-4 CASTELLATED NUT
MS24665-212 COTTER PIN
NAS1149C0432 WASHER

VIEW G-G

AN3C11A BOLT
NAS1149C0332 WASHER
MS21043-3 NUT
2 PL

D3953-5
GAS SPRING STUD
REF

D3953-11
GAS SPRING SPACER

D3953-9
GAS SPRING WASHER

AN310-4 CASTELLATED NUT
MS24665-212 COTTER PIN
NAS1149C0432 WASHER

D3969-1
GAS SPRING
REF

VIEW H-H

G G

D3953-15
GAS SPRING BRACKET
REF

TRANSFER MARK AND
DRILL Ø0.194 THRU

TRIM MESH LOCALLY
AS REQUIRED

DETAIL C

H H

D3953-5
GAS SPRING STUD
REF

TRIM MESH LOCALLY
AS REQUIRED

TRANSFER MARK AND
DRILL Ø0.194 THRU

D3969-1
GAS SPRING
REF

DETAIL D

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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND DRAWING D350-607 REV. F OR SUBSEQUENT APPROVED REVISION

REF CANADIAN STC: SH94-14

FAA STC: SR00213NY

EASA STC: EASA.IM.R.S.01405

THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI), IS TO PROVIDE OPERATORS OF AS350 / 355 ROTORCRAFT EQUIPPED WITH DART D350-607-041 HELI UTILITY BASKETS WITH AN UPGRADE KIT TO REPLACE THE EXISTING LID PROP ARM WITH 2 GAS SPRINGS.

FOR OPERATORS EQUIPPED WITH D350-607-043/-045/-047 HELI UTILITY BASKETS THIS DSI WILL PROVIDE AN UPGRADE KIT TO REPLACE THE EXISTING LID PROP ARM WITH 1 GAS SPRING.

ITEM No.	QTY -141	QTY -143	QTY -145	PART NUMBER	DESCRIPTION
1	X			D350-607-141	GAS SPRING KIT INSTALLATION (FOR USE ON -041 BASKET*)
2		X		D350-607-143	GAS SPRING KIT INSTALLATION (FOR USE ON -043/-047 BASKET*)
3			X	D350-607-145	GAS SPRING KIT INSTALLATION (FOR USE ON -045 BASKET*)
4	2		1	D3953-1	GAS SPRING BRACKET
5	2	1	1	D3953-3 20	GAS SPRING STUD (LID)
6	2	2	1	D3953-5 20	GAS SPRING STUD (BASE) Make 52x34x10 wip
7	2		1	D3953-7	GAS SPRING SPACER
8	4	2	2	D3953-9 40	GAS SPRING WASHER
9	2	1	1	D3953-11 40	GAS SPRING SPACER
10	2		1	D3953-13	GAS SPRING SPACER
11		1		D3953-15 4	GAS SPRING BRACKET make
12		1		D3953-17 14	GAS SPRING SPACER
13	2	1	1	D3969-1 wip	GAS SPRING
14	4	2	2	AN3C11A	BOLT
15		2		AN3C15A	BOLT
18	4		2	AN3C16A	BOLT
19	4	2	2	AN310-4	CASTELLATED NUT
20	8	4	4	MS21043-3	NUT
21	4	2	2	MS24665-212	COTTER PIN
22	8	4	4	NAS1149C0332R	WASHER (OR AN960C10L)
23	4	2	2	NAS1149C0432R	WASHER (OR AN960C416L)

REFERENCE ONLY

***NOTE:** FOR CUSTOMERS WISHING TO ORDER NEW BASKETS WITH THE GAS SPRING KIT PRE-INSTALLED USE THE FOLLOWING NUMBERS:

D350-607-041 BASKET WITH GAS SPRING UPGRADE KIT = D350-607-041A

D350-607-043 BASKET WITH GAS SPRING UPGRADE KIT = D350-607-043A

D350-607-045 BASKET WITH GAS SPRING UPGRADE KIT = D350-607-045A

D350-607-047 BASKET WITH GAS SPRING UPGRADE KIT = D350-607-047A

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
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BY:	D. SHEPHERD (DE # 02)
DATE:	09.11.04
CERT. NO.:	SH94-14
ISSUE NO.:	4

B	SHT 1 P/L ITEM 22 WAS NAS1149C0332 ITEM 23 WAS NAS1149C0432H. ALL OTHER SHEETS UPDATED ACCORDINGLY. (REASON: DRAFTING ERROR)	AJS	09.11.03
A	NEW ISSUE	AJS	09.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9473	SHEET 1 OF 8
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